

Work Order ID 109910

December-05-13 2:34:28 PM

Item ID: D3488-041

Revision ID:

**Item Name:** Blade Fitting LH

**Start Date:** 12/05/13 **Start Qty:** 12.00

✓ 1/18 Q-3

## Accept

910\*

Page 1

**Start Date:** 12/05/13 **Start Qty:** 12.00

\*12\*

**Cust Item ID:**

Required Date: 12/19/13 Req'd Qty: 12.00

\*12\*

**Customer:**

### Reference:

Approvals:      Process Plan: ML3

Date: 13-12-05

## Tooling:

Date:

### Run Start

\*NR1\*

Stop

\*NP2\*

OC;

Date:

SPC (Y/N):

Date:

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only 

Work Order: _____	DISPOSITION			AGAINST DEPARTMENT/PROCESS					
Part No. _____	Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>				
NCR No. _____	Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>				
	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>				
	Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>					

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

## FAULT CATEGORY

Landing Gear	General				
Bending	Bend <input type="checkbox"/>	Folio/Program <input type="checkbox"/>	Outside Dimensions <input type="checkbox"/>	Pressure/Forced <input type="checkbox"/>	
Centre Not Concentric	BOM/Route <input type="checkbox"/>	Grain <input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>	Set-up <input type="checkbox"/>	
Cracks	Broken/Damage/Defect <input type="checkbox"/>	Hardware <input type="checkbox"/>	Part Incorrect <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/>	
Crimp/Kink/Ripple/Wave	Burrs <input type="checkbox"/>	Inspection Incomplete/Unqualified <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>	Weld <input type="checkbox"/>	
Cuffs	Contamination <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>	Part Moved <input type="checkbox"/>	Wrong Stock Pulled <input type="checkbox"/>	
Crushing	Countersink <input type="checkbox"/>	Misaligned/off center <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>		
Heat Treat	Cut Too Short <input type="checkbox"/>	Mislabeled <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>		
Inspection Strip in Tube	Drawing <input type="checkbox"/>	Misread <input type="checkbox"/>			
Marks/Chatter	Drill Holes <input type="checkbox"/>	Off-set <input type="checkbox"/>			
Turning Sequence	Finish <input type="checkbox"/>	Out of Calibration <input type="checkbox"/>			
Wave/Twist in Tube	Fit/Function <input type="checkbox"/>	Out of Sequence <input type="checkbox"/>			

**Work Order ID 109910****\*109910\***

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December-05-13 2:34:28 PM

Item ID: D3488-041

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Blade Fitting LH

Stop

**\*NS2\***

Start Date: 12/05/13 Start Qty: 12.00

**\*12\***

Cust Item ID:

Required Date: 12/19/13 Req'd Qty: 12.00

**\*12\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 <b>*120*</b> HAAS 1	HAAS CNC VERTICAL MACHINING #1 Memo HAAS CNC vertical machine #1	0.00	<i>2</i>	<i>13/12/23</i>		<i>10</i>	<i>0</i>		
130 <b>*130*</b> QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00	<i>2</i>	<i>13/12/23</i>		<i>10</i>	<i>0</i>		
140 <b>*140*</b> QC Quality Control	QC8- Inspect parts - second check Memo	0.00	<i>3</i>	<i>14/01/08</i>		<i>6</i>	<i>0</i>		<i>DAS 08 9-89</i>

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Date:

## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

## Work Order update only



Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION		AGAINST DEPARTMENT/PROCESS								
Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>				Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>		Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>		Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>		Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>				
Root Cause		Date	Step	Qty	Description of work order update or non-conformance		Initial Chief Eng	Action Description		Sign & Date	Verification	QC Inspector		
Design	<input type="checkbox"/>													
Doc/Data	<input type="checkbox"/>													
Equip/Tooling	<input type="checkbox"/>													
Handling/Pre	<input type="checkbox"/>													
Material	<input type="checkbox"/>													
Operator	<input type="checkbox"/>													
Offset/Setup	<input type="checkbox"/>													
Process	<input type="checkbox"/>													
Supplier	<input type="checkbox"/>													
Training	<input type="checkbox"/>													
Transport	<input type="checkbox"/>													
Unapproved	<input type="checkbox"/>													
FAULT CATEGORY														
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function			<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence				<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled	
<input type="checkbox"/> Other														

Work Order ID 109910

\*109910\*

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Item ID: D3488-041

Accept

\*N900040100\*

Setup

Start

\*NS1\*

Revision ID:

Item Name: Blade Fitting LH

Stop

\*NS2\*

Start Date: 12/05/13 Start Qty: 12.00

\*12\*

Cust Item ID:

Required Date: 12/19/13 Req'd Qty: 12.00

\*12\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 <b>*150*</b> HandFinish	Chemical Conversion Coat per QSI005 4.1	0.00							<i>6 76 14-10</i>
	Memo	0.00							
160 <b>*160*</b> Powdercoat	White Gloss(Ref 4.3.5.1) per QSI005 4.3-Alum	0.00							<i>6 14-14</i> <b>DAS</b> 34 9-89
	Memo	0.00							
	START TIME: <i>5:00</i>	<i>8:50</i>	OPEN TEMPERATURE:	<i>9:00</i>					
	FINISH TIME:								
170 <b>*170*</b> QC	QC3- Inspect Part Finish	0.00							<i>6 14-02-11</i>
	Memo	0.00							

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only 

Work Order: _____ Part No. _____ NCR No. _____	<b>DISPOSITION</b> Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled	

**Work Order ID 109910****\*109910\***

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Item ID: D3488-041

Accept

**\*N900040100\***

Setup

Start

**\*NS1\***

Revision ID:

Item Name: Blade Fitting LH

Stop

**\*NS2\***

Start Date: 12/05/13 Start Qty: 12.00

**\*12\***

Cust Item ID:

Required Date: 12/19/13 Req'd Qty: 12.00

**\*12\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 <b>*180*</b> HandFinish	HandFinishing	0.00							6611 f 9K 14/02/14
Hand Finishing	Memo	0.00							
	Install Inserts as per Dwg D3488								
190 <b>*190*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O	0.00							6 φ 4-211 DAS 34 08
	Memo	0.00							
200 <b>*200*</b> Packaging Packaging	Identify as per dwg & Stock Location: <u>FP 60</u>	0.00							6611 f 9K 14/02/14
	Memo	0.00							

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Date:



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

## Work Order update on

**Work Order ID 109910**

\*109910\*

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December-05-13 2:34:28 PM

Item ID: D3488-041 Accept \*N900040100\* Setup Start \*NS1\*  
Revision ID: Stop \*NS2\*  
Item Name: Blade Fitting LH  
Start Date: 12/05/13 Start Qty: 12.00 \*12\* Cust Item ID:  
Required Date: 12/19/13 Req'd Qty: 12.00 \*12\* Customer:  
Reference:  
Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	QC21- Final Inspection - Work Order Release	0.00							
<b>*210*</b> QC	Memo	0.00							<u>01/14-02-13</u>

(H) 14-02-11

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only 

Work Order: _____			DISPOSITION		AGAINST DEPARTMENT/PROCESS					
			Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>			
			Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>			
			Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>			
			Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>				
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector	
Design										
Doc/Data										
Equip/Tooling										
Handling/Pre										
Material										
Operator										
Offset/Setup										
Process										
Supplier										
Training										
Transport										
Unapproved										
FAULT CATEGORY										
Landing Gear			General							
<input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			<input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function							
			<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence							
			<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge							
			<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled							
			<input type="checkbox"/> Other							

# Picklist Print

Page 1

December-05-13 2:34:32 PM

Work Order ID: 109910

\*109910\*  
\*D3488-041\*

Parent Item: D3488-041

Parent Item Name: Blade Fitting LH

Start Date: 12/05/13

Required Date: 12/19/13

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 06-02-28 JLM  
IPP Rev:B As per Rev B 06-03-30 JLM  
IPP Rev:C Now On Doosan Lathe JLM Verified BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

ALS7-1032-225	Purchased	No				Each	92.0000		48	24			
<b>*AI S7-1032-225*</b> ✓ ALS4-1032-225 <small>Insert</small>													

Location	Loc Qty	Loc Code
FG	80	
118520	80	
ST280	12	
122333	12	

D6103-003	Manufactured	No		Each	26.0000	12	
<b>*D6103-003*</b> <small>Round Billet, Aluminum</small>							
<small>DAS 40 13/12/11 9-89</small>							

Location	Loc Qty	Loc Code
MAT043	10	
109281	10	
MAT047	16	
✓106711	10	
95020	4	
96416	2	

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Date:



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

## Work Order update only

Work Order Update Only				Disposition		Against Department/Process																		
Work Order:				Rework		Skid-tube		Crosstube		Water Jet		Engineering												
Part No.				Scrap		Machining		Small Fab		Prod. Eng. Coor.		Quality												
NCR No.				Use-as-is		Thermoforming		Finishing		Rec/Store/Packaging		Other												
				Suspected Unapproved		Large Fab		Composite		Supplier														
Root Cause	Date	Step	Qty	Description of work order update or non-conformance		Initial Chief Eng	Action Description		Sign & Date	Verification	QC Inspector													
Design																								
Doc/Data																								
Equip/Tooling																								
Handling/Pre																								
Material																								
Operator																								
Offset/Setup																								
Process																								
Supplier																								
Training																								
Transport																								
Unapproved																								
Fault Category																								
Landing Gear				General																				
<input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				<input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function									<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence				<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge				<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled			

DART AEROSPACE LTD	Work Order:	109910
Description: Blade Fitting, LH / Turning Detail for D3488-1/2	Part Number:	D3488-1
Inspection Dwg: D3488 / DSK101 Rev: B / D		Page 1 of 2

### FIRST ARTICLE INSPECTION CHECKLIST

First Article  Prototype

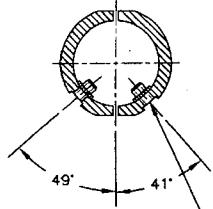
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Lathe Section						
Ø2.150	+/-0.005	2.152	✓		VGW	P10-12
Ø2.780	+/-0.005	2.779	✓		MIC	P10-04
Ø3.125	+/-0.010	3.123	✓		VGW	P10-12
Ø3.346	+/-0.010	3.345	✓		"	"
0.125 x 45°	+/-0.010 x +/-0.1°	.125	✓		"	"
8.000	+0.030/-0.000	8.015	✓		"	WC-02
9.250	+/-0.010	9.250	✓		"	"
0.188	+/-0.010	.185	✓		"	"
R0.032	+/-0.010	.032	✓		Rad G	
R0.062	+/-0.010	.062	✓		"	
Ø0.297	+0.005/-0.001	.299	✓		VGW	P10-12
Ø0.430	+/-0.010	.434	✓		"	"
0.100	+/-0.010	.097	✓		"	"
0.125	+/-0.010	.130	✓		VGW	P10-12
2.620	+/-0.010	2.620	✓		VGW	P10-12
3.500	+/-0.010	3.500	✓		"	"
1.005	+/-0.010	1.005	✓		"	"
Ø0.484	+0.005/-0.001	.486	✓		"	"
1.180	+/-0.010	1.178	✓		"	"
3.150	+/-0.010	3.148	✓		"	"
3.070	+/-0.010	3.070	✓		"	"
R0.063	+/-0.010	.063	✓		Rad G	

DART AEROSPACE LTD		Work Order:	109910
Description: Blade Fitting, LH / Turning Detail for D3488-1/2		Part Number:	D3488-1
Inspection Dwg: D3488 / DSK101 Rev: B / D			Page 2 of 2

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
<b>Milling Section</b>						
Ø0.508	+0.006/-0.001	.507	—		Vern	11-06
0.750	+/-0.010	.750	—		"	
1.500	+/-0.010	1.506	—		"	
11.18	+/-0.030	11.176	—		"	
R0.062	+/-0.010	R.062	—		R-6	
0.125	+/-0.010	.123	—		Vern	11-06
0.590	+/-0.010	.588	—			
0.793	+/-0.010	.794	—		"	
1.351	+/-0.010	1.351	—		"	
1.317	+/-0.010	1.321	—		"	
1.802	+/-0.010	1.803	—		"	

Measured by: <i>40</i> 9-08	<i>13/12/23</i>	Audited by: <i>D.A</i> <i>08</i> 9-08	Prototype Approval: N/A
Date: <i>13/12/16</i>	<i>13/12/23</i>	Date: <i>14/01/08</i> 9-08	Date: N/A

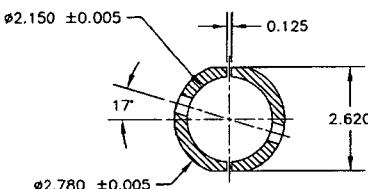
Rev	Date	Change	Revised by	Approved
A	06.03.31	New Issue	KJ/JLM	
B	08.09.19	Reformat P/O D3488-041	KJ/JLM	
C	08.12.02	Dimension 8.000 removed	KJ/JLM <i>11/12/08</i>	<i>2011</i>



SECTION B-B

Φ0.297  
C'BORE  $\Phi 0.430 \times 0.100$   
INSTALL ALS4-1032-225 (OR AKS4-1032-225  
OR ALS7-1032-225 OR AKS7-1032-225)  
INSERTS AFTER FINISH  
(4 PLACES)

4



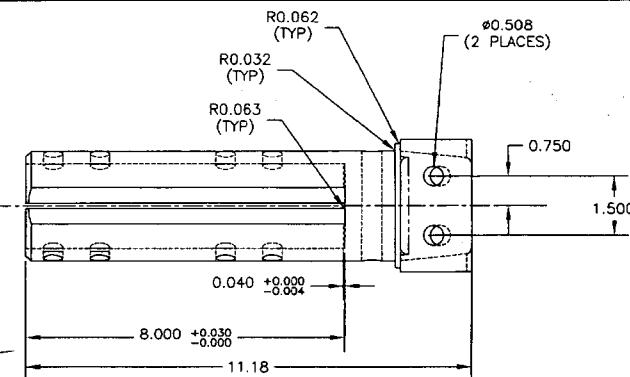
SECTION A-A

D3488-041/-042 BLADE FITTING ASSEMBLY PARTS LIST

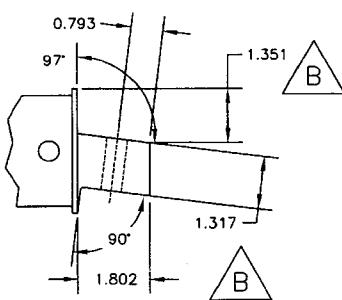
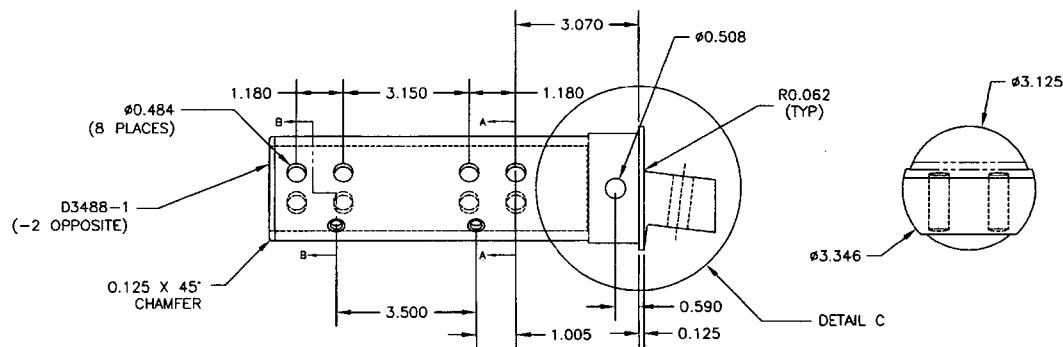
QTY	QTY	PART NUMBER	DESCRIPTION
1	1	D3488-041	BLADE FITTING ASSEMBLY (LH)
X	X	D3488-042	BLADE FITTING ASSEMBLY (RH)
1	1	D3488-1	BLADE FITTING (LH)
1	1	D3488-2	BLADE FITTING (RH)
4	4	ALS4-1032-225 or AKS4-1032-225 or ALS7-1032-225 or AKS7-1032-225	INSERT

D3488-041/-042 BLADE FITTING

- 1) MATERIAL: MAKE D3488-1/-2 FROM ALUMINUM 7075-T7351 ROUND BAR  
PER QQ-A-225/9  
(REF. DART MATERIAL SPEC M7075T73R)
- 2) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (REF 4.3.5.1) -PER DART QSI 005 4.3
- 3) BREAK UNMARKED SHARP EDGES 0.010 TO 0.020
- 4) INSTALL INSERTS AFTER POWDER COAT
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



109910 MCL  
13-12-05



DETAIL C

D3488-041 SHOWN (D3488-042 OPPOSITE)

RELEASED  
04-03-05 PH  
PER 05  
EIN #737

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DART AEROSPACE USA, INC.

B	06.03.15	CHANGE THICKNESS
A	05.12.20	NEW ISSUE
DESIGN	PH	DRAWN BY
CHECKED	PH	APPROVED
DATE	06.03.15	TITLE
		SCALE

DART AEROSPACE USA, INC.  
PORT HADLOCK, WA

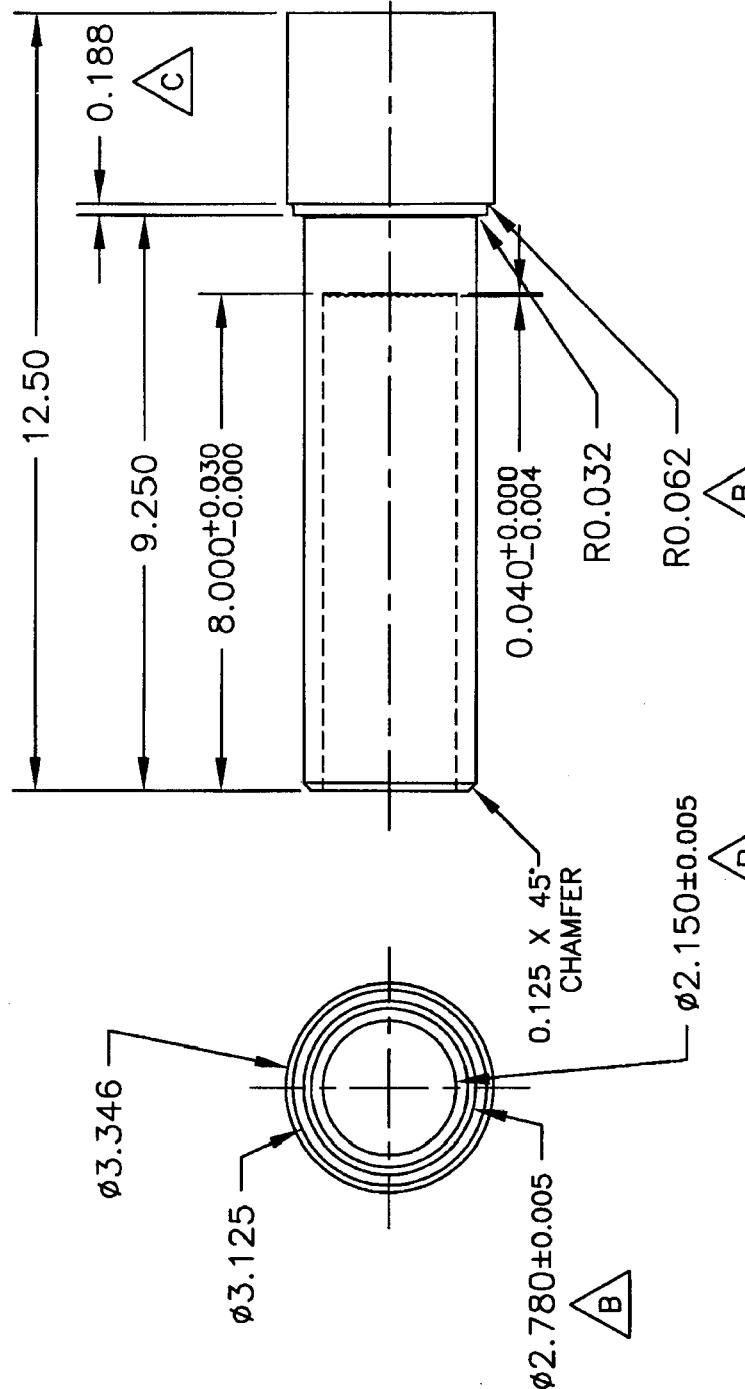
REV. B  
D3488  
SHEET 1 OF 1

BLADE FITTING

109916

**DART**

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. DSK 101
DATE		REV. D SHEET 1 OF 1
06.05.09		TITLE D3488-1/-2 TURNING DETAIL
A	05.12.21	SCALE 1:3
B	06.03.02	ADD TOLERANCES AND RADIUS
C	06.04.17	0.188 WAS 0.125
D	06.05.09	REMOVE DIAMETER FOR CHAMFER



DSK 101

- 1) MATERIAL: MAKE FROM ALUMINUM 7075-T7351 ROUND BAR PER QQ-A-225/9  
(REF. DART MATERIAL SPEC M7075T73R)
- 2) FINISH: NONE
- 3) BREAK UNMARKED SHARP EDGES 0.010 TO 0.020
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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